

What is claimed is:

1. An imitation candle comprising:
 - a wax shell having a central cavity with an interior surface;
 - an insert having a different thermal coefficient of expansion than the wax, positioned in the central cavity; and
 - a gap between the insert and the interior wall of the central cavity extending from an entry surface of the shell partway up the central cavity.
2. An imitation candle as set forth in claim 1, further comprising:
 - a bonding layer between a portion of the insert and the interior surface of the wax shell, the bonding layer extending from a deepest point of the cavity toward the entry surface to define the gap between the insert and the interior surface near any exterior edges of the wax shell.
3. An imitation candle as set forth in claim 2, wherein the bonding layer retains the insert in the shell.
4. An imitation candle as set forth in claim 1, further comprising:
 - the gap being filled with air.
5. An imitation candle as set forth in claim 3, further comprising:
 - the gap being filled with air.
6. An imitation candle as set forth in claim 3, further comprising:
 - the bonding layer being formed from the same wax as the shell, but poured in a separate casting after the shell has hardened.
7. An imitation candle as set forth in claim 5, wherein the central cavity and the gap extend into the shell from a bottom surface of the shell.
8. An imitation candle as set forth in claim 4, wherein the central cavity and the gap extend into the shell from a bottom surface of the shell.
9. An imitation candle as set forth in claim 7, further comprising:

the insert providing a source of artificial illumination.

10. An imitation candle as set forth in claim 8, further comprising:

the insert providing a source of artificial illumination.

11. An imitation candle as set forth in claim 6, further comprising:

a plurality of edges between surfaces of the shell exhibiting substantial angles of intersection being rounded.

12. An imitation candle as set forth in claim 1, further comprising:

a plurality of edges between surfaces of the shell exhibiting substantial angles of intersection being rounded.

13. A process for making an imitation candle comprising the steps of:

casting a shell from molten wax;

forming a central cavity from a bottom surface of the shell into the interior of the shell;

after hardening of the shell making a second casting of wax within the central cavity,

the second casting comprising a substantially reduced quantity of wax; and

inserting a module into the central cavity, the act of inserting displacing molten wax of the second casting to form a bonding layer between the module and the shell.

14. The process as claimed in claim 13, further comprising the step of:

after leaving a gap between a portion of the module and the interior surface of the central cavity.